

Date: Friday, 26/01/2007 1:59:08 PM  
 User: Linda Lacelle

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 30483  
**Estimate Number** : 10937  
**P.O. Number** : N/A  
**This Issue** : 26/01/2007 **S.O. No.** : N/A  
**Prsh Rev.** : NC  
**First Issue** : N/A **Type** : MACHINED PARTS  
**Previous Run** : 30301  
**Written By** :    
**Checked & Approved By** :  
**Comment** : Est: B 00.06.26 New DWG rev (mpp 2069) EC

**Drawing Name** : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW  
**Part Number** : D29392  
**Drawing Number** : D2939 UNDER REVIEW *b1c 07.01.26*  
**Project Number** : N/A  
**Drawing Revision** : B  
**Material** : N/A  
**Due Date** : 12/02/2007 **Qty:** 6 **Um:** Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No: <u>25343 2X</u> <i>MS 07/02/03</i> <u>23934 4X</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr <i>MS 07/02/03 6</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
		<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>MS 07/02/03 6</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET. 
		<b>Comment:</b> INSPECT ALL DIM TO DIM SHEET <i>MS 07/02/03 6</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.26	2	TOOL RAD FOR FLANGE POKETS SHOULD BE R0.188				CP 07.01.26 per OSI 042	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/02/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 1:59:08 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 30483

Part Number: D29392

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

206/02/05 6

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 07/02/05

(6)

7.0 POWDER COATING

POWDER COATING



ATTN: M103141 PAINT 1 pc grey



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.a/4

07/02/08

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



CB01/02/09



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST483

CB01/02/09(6) 0



(6)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/12

(6)

Job Completion



U 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30483
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				S By	G Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.120	.121	.120	.120
B	0.100	0.140		.120	.120	.120	.120	.120	.120
C	0.100	0.140		.127	.128	.128	.127	.125	.125
D	0.210	0.230		.225	.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.510	.510	.510	.510	.510
I	1.572	1.582		1.580	1.578	1.578	1.578	1.578	1.578
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262	DT8683	.258	.258	.258	.258	.258	.258
L	0.312	0.317	DT8686	.313	.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.238	.238	.238	.238
N	0.100	0.140		.124	.125	.125	.125	.124	
O	0.540	0.560		.549	.550	.550	.551	.550	.550
P	0.490	0.510		.505	.505	.504	.504	.504	
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.742	2.750	2.750	2.750	2.750	2.750
S	0.240	0.270		.250	.250	.250	.250	.250	.250
T	0.100	0.180		.140	.140	.140	.140	.140	.140
U	1.625	1.635		1.632	1.632	1.632	1.630	1.632	1.630
V	1.362	1.372		1.369	1.370	1.370	1.370	1.370	1.370
W	0.316	0.321	DT8690	.318	.318	.318	.318	.318	.318
X	1.250	1.270		1.265	1.265	1.265	1.265	1.262	1.262
Y	1.565	1.585	DT8695 A/B	1.573	1.573	1.570	1.570	1.570	1.570
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	MS	Audited by:	TM
Date:	07/02/05	Date:	07/02/05

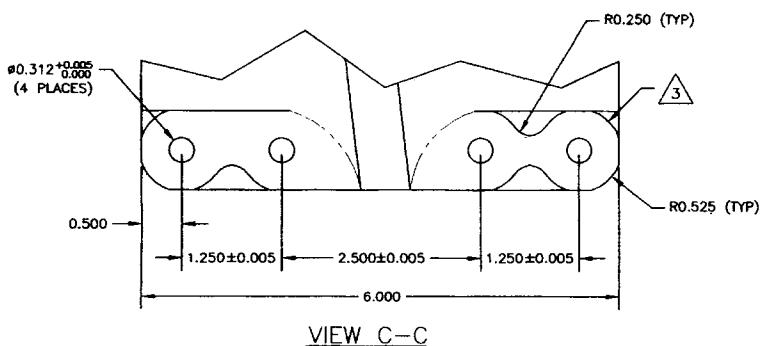
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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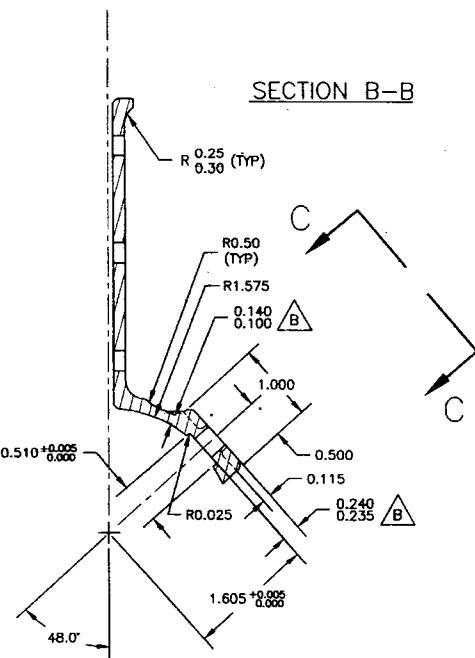


VIEW C-C

D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

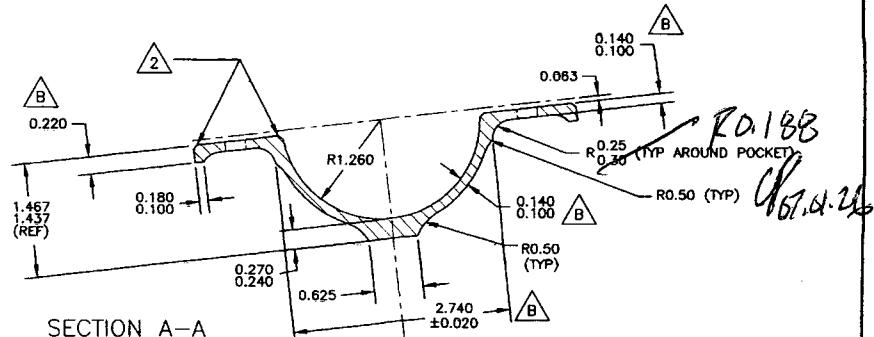
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



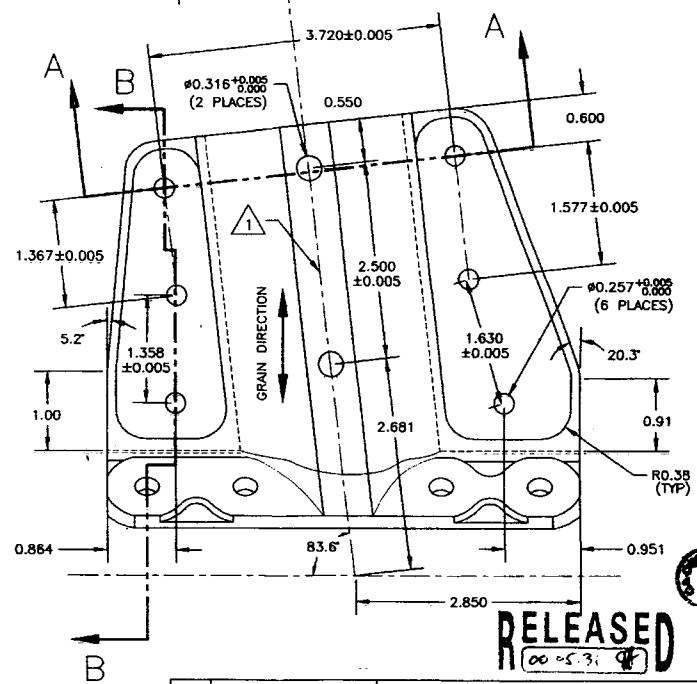
UNDER REVIEW

06.11.09 CB  
Change R0.30

W  
30483



SECTION A-A



RELEASED  
00-53:4

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DART AEROSPACE USA, INC.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. SELLVILLE, OH
checked	RF	REV. B
CHECKED	APPROVED	DRAWING NO. D2939
DATE		SHEET 1 OF 1
00.05.29	TITLE	SCALE 2:1
	SADDLE INSIDE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

**Chris Provencal**

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 19, 2006 3:31 PM  
**To:** 'S Shahbazian'  
**Cc:** 'Provencal, Chris'; 'Charbonneau, Eric'  
**Subject:** RE: Radius dimension on the saddle  
**Importance:** High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.  
See D2661 to D2668 as well as D2932 to D2933.

David

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**From:** S Shahbazian [mailto:[sshahbazian@dartaero.com](mailto:sshahbazian@dartaero.com)]  
**Sent:** Thursday, October 19, 2006 1:16 PM  
**To:** Shepherd, David  
**Cc:** Provencal, Chris; Charbonneau, Eric  
**Subject:** Radius dimension on the saddle

Dave,  
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188  
since the tooling has been changed long time ago, and apparently they have been machining those radiiuses to  
0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the  
changes.

Serge

--  
No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

--  
No virus found in this outgoing message.  
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